

Date: Thursday, 3/27/2008 7:42:11 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HELI-ACCESS HANDLE
Job Number : 38228	
Estimate Number : 11829	
P.O. Number :	Part Number : D2479
This Issue : 3/27/2008 S.O. No. :	Drawing Number : D2479 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 37463	Material :
Written By :	Due Date : 4/10/2008 Qty: ¹² / ₄ Um: Each
Checked & Approved By : <u>JO 08.3.27</u>	
Comment : Est. B 99.03.12 Updated from hand written IPP DM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 1.4000 f(s)/Unit Total : 5.5999 f(s)
 304 RD Tube .750 x .049W
 Material: 304/316 SS Seamless 0.75" OD x 0.049" Wall
 Batch M107518

FF 08-04-01

(12)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut as per Template DT8334 (DT 2479 CT)

FF 08-04-01

(12)

3.0	BENDING	BENDING MACHINE
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Comment: BENDING MACHINE
 Bend as per Template DT 8335 (DT 2479 BT)
 Trim as per Template DT 8333 (DT 2480 CJ)
 Deburr

FF 08-04-01

(12)

FF 08/04-03

(11)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 08/04/03 (12)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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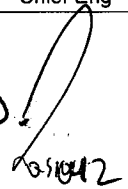

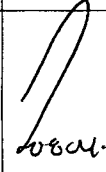
Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: SP

Cpl 08.04.04

(X11)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2479 PAR #: NA Fault Category: Prod / AB. ASS. mod & small NCR: Yes No DQA: D Date: 08/04/14
D205-626 QA: N/C Closed: D Date: 08/04/14

NCR: 38228		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/03	3	1 D2479 Damaged beyond repair (cut into milling machine)	 08/04/03	Destroyed not replaced	08/04/03 FF	SB 08/04/03	 08/04/03	 08/04/03

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS HANDLE

Job Number: 38228

Part Number: D2479

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/04

[Signature]

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



umf

08-04-03

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

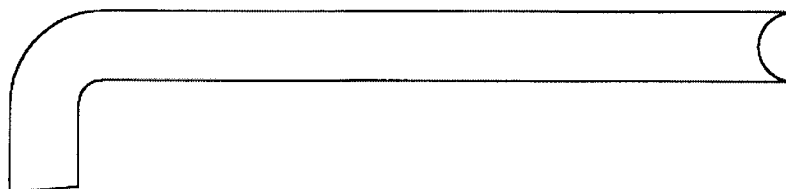
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN B WILLIAMS	DRAWN BY MIKE M	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2479	REV. A SHEET 1 OF 1
DATE 96:05:14		TITLE HELI-ACCESS HANDLE	SCALE 1:1

RELEASED
96/10/02 DS



CUT PER TEMPLATE DT 2479 CT
BEND PER TEMPLATE DT 2479 BT
TRIM PER TEMPLATE DT 2480 CJ

MATERIAL: 304/316 0.75 OD 0.049 WALL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38228